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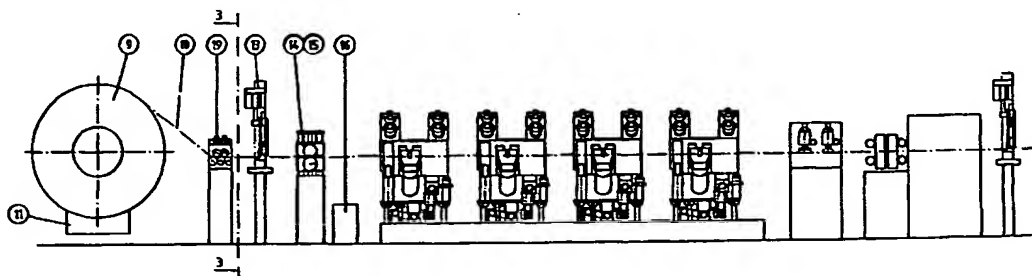
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(54) Title: A PRODUCTION LINE AND A METHOD OF FORMING PROFILES



(57) Abstract: Profiles (50) are formed in a production line with a cross-section that varies along their length from a plane metal strip (10) that is unwound from a coil (9), whereby edge cutters (14) and a number of roll-forming units (17-24) are used where not only the edge cutters but also the roll-forming units can be displaced individually sideways relative to the strip. The edge cutters (14) and the roll-forming units (17-24) are individually controlled such that they follow the lines of extent of the side edges (51, 52) that are cut and the lines of the corners (53-56) that are subsequently formed, and the forming of one corner with a number of roll-forming units is started only after the forming of a corner that lies more closely to the edge of the strip has been completed. The formed profile is bent in a bending station integrated into the line, which bending station comprises rollers (35-40) that can be controlled to roll sections of the profile (50) to become thinner such that the profile is bent or twisted as it is formed.

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